

Date: Thursday, 14/08/2008 10:54:37 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FWD BLADE FOLD ASSEMBLY
Job Number :	41237		
Estimate Number :	13531		
P.O. Number :		Part Number :	PB674300101
This Issue :	14/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.1, 2
First Issue :	1/1	Project Number :	N/A
Previous Run :		Drawing Revision :	B1
	Type :	Material :	
	SMALL / MED FAB	Due Date :	18/08/2008
Written By :		Qty:	3
Checked & Approved By :	<u>mf 08-08-24</u>	Um:	Each
Comment :	Est Rev:A 08-07-30 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB674300107	Fwd Blade Fold Assembly Weldment

Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Fwd Blade Fold Assembly Weldment

batch: 340771

mf 08-08-25 3

2.0	PB674300115	Fwf Adjustable Blade Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Fwf Adjustable Blade Support Assembly

batch: 340608

mf 08-08-25 3

3.0	PB674300111	Fwf Adjustable Blade Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Fwf Adjustable Blade Support Assembly

batch: 340606

mf 08-08-25 3

4.0	PB674300121	PB67-43001-21
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

PB67-43001-21

batch: 41292 36953

mf 08-08-24

5.0	PB674300123	PB67-43001-23
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

PB67-43001-23

batch: 41293 36259

mf 08-08-24

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Part Number: PB674300101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PB674300145	Longitudinal Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Longitudinal Support Assembly

batch: 41013

me 08-08-26

7.0	PB674300151	Long T-Handle Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Long T-Handle Assembly

batch: 340110

08-08-25

8.0	PB6743001261	Lever Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Lever Arm

batch: 340054 x 2, 41411 x 4

08-08-25

9.0	PB6743001265	Bushing
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bushing

batch: 340056

08-08-25

10.0	PB6743001299	Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bushing

batch: 340062

08-08-25

11.0	D3451043	Handle and Lock-Down Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Handle and Lock-Down Assembly

batch: 341064

No Qty 08-08-25

12.0	D3451047	Handle and Lock-Down Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Handle and Lock-Down Assembly

batch: 341063

No Qty 08-08-25

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Seq. #:

Machine Or Operation:

Description :

13.0

D34473

Square Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Square Spacer

batch:

24416

AS 08/08/14 (X3)

14.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Swing Arm

batch:

39965

AS 08/08/27 (X3)

15.0

D3445041

Belt Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Belt Assembly

batch:

B24248 x1 B39966 x2

AS 08/08/14 (X3)

16.0

086004

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Inventory

batch:

17850

AS 08/08/14 (X3)

17.0

MS27039104

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Inventory

batch:

M18431

AS 08/08/14 (X3)

18.0

MS27039123

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

SCREW

batch:

18057

AS 08/08/14 (X3)

19.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Nut

batch:

107665

AS 08/08/14 (X3)

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Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS21042L4

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total: 30.0000 Each(s) •

Nut

batch:

108488

AS 08/08/14 (X3)

21.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut

batch:

105077

AS 08/08/14 (X3)

22.0

MS518596

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 24.0000 Each(s)

WASHER

batch:

M106277

AS 08/08/14 (X3)

23.0

MS518598

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 24.0000 Each(s)

WASHER

batch:

18854

AS 08/08/14 (X3)

24.0

NAS43DD368

SPACER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

SPACER

batch:

102850 X3 M108473 X3.

AS 08/08/14 (X3)

25.0

NAS1149F0316P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

WASHER

batch:

106242

AS 08/08/14 (X3)

26.0

NAS1149F0432P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 48.0000 Each(s)

Washer

batch:

106057

AS 08/08/14 (X3)

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Job Number: 41237

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

NAS1149F0632P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 24.0000 Each(s)

WASHER

batch: 108057

NS 08/08/14 (x3)

28.0

NAS1149F0832P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

WASHER

batch: 108057

NS 08/08/14 (x3)

29.0

AN960JD6

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Washer

batch: 6085

NS 08/08/14 (x3)

30.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bolt

batch: 105442

NS 08/08/15 (x3)

31.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bolt

batch: M107959

NS 08/08/15 (x3)

32.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bolt

batch: 19278

NS 08/08/15 (x3)

33.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

BOLT

batch: 105550

NS 08/08/15 (x3)

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Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN620A

Bolt



✓



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bolt

batch:

104547

AS 08/08/15 (X3)

35.0

AN813A

BOLT



✓



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

BOLT

batch:

18180

AS 08/08/15 (X3)

36.0

BSP43

RIVET



✓



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

RIVET

batch:

17890

AS 08/08/15 (X3)

37.0

CR3213405

cherry rivet



✓



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

cherry rivet

batch:

104214

AS 08/08/15 (X3)

38.0

MS17984C408

PIN, QUICK RELEASE



Batch unknown

due to w/o switch, last 3.

Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

PIN, QUICK RELEASE

batch:

M108986

✓

AS 08/08/15 (X3)

39.0

MS17984C418

PIN, QUICK RELEASE



✓



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

PIN, QUICK RELEASE

batch:

106277

AS 08/08/15 (X3)

40.0

30345T22

8" LANYARD



✓



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

8" LANYARD

batch:

M102812 x 2 M17828 x 4

AS 08/08/15 (X3)

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Job Number: 41237

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

30345T24

LANYARDS



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

LANYARDS

batch:

M18351

✓

AS 08/08/15 (X3)

42.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 8.0000 Each(s)/Unit Total: 24.0000 Each(s)

SPRING SLOTTED PIN

batch:

M102940

✓

AS 08/08/15 (X3)

43.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2

242 THREADLOCK batch: M107045

PL 08.08.25

(X3)

44.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/06 (X3)

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

* 39952

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/27

Job Completion



MF 08/08/26

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REV STATUS OF SHEETS	REV	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45
SHEET		1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45

REVISIONS		
REV	DESCRIPTION	DATE
1	MFG. RELEASE	10/12/95
2	CHANGES TO IMPROVE FUNCTIONALITY	3/7/96
3	DWG AND P/L REVISED AND UPDATED TO REFLECT BELL MODIFICATIONS	8/15/96
4	CHANGED DIMENSIONS AFTER FIT	8/26/96

FUNCTION TEST CASE TP-042-685-10

NOTES (UNLESS OTHERWISE SPECIFIED):

- IDENTIFY PARTS PER PREMIER IDENTIFICATION AND MARKING PROCEDURES 115-12112. LOCATION, CHARACTER HEIGHT, AND PROCESS AS REQUIRED. MARK IN CONTRASTING COLOR.
- FOR SHEET METAL PARTS, REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .01-.03, EXCEPT AS NOTED. FOR MACHINED PARTS, REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .015 MAX, EXCEPT AS NOTED.
- GENERAL SHOP PRACTICES I.A.W. PREMIER SPEC. 008-93000 AND AC43.13.
- OPEN
- WELD PARTS PER MIL-2219, CLASS B.
- CHEM FILM (ALODINE) ALL ALUMINUM DETAIL PARTS PER PREMIER SPEC 008-93003, CLASS 1A, AND PRIME WITH EPOXY PRIMER PER MIL-P-25377C, ZINC CHROMATE PRIMER PER MIL-TTP-1757, OR EQUIVALENT.
- STITCHING PER FED-STD-751.

- SECURE -43 BELT ASSY TO TOP OF -65 (OF -05) OR -47 (OF -07). LOCATE APPROX AS SHOWN.
- WITH -137 SLEEVE IN OPEN POSITION, LOCATE RIVET APPROX AS SHOWN, TO SERVE AS A STOP FOR -137
- DRILL WITH -37 AT VERTICAL FULL OPEN POSITION. DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION, ASSURING -37 CLEARS ADJACENT STRUCTURE.
- SHIM AS REQD. USING NAS1149D0332J WASHERS.
- 01 FWD BLADEFOLD ASSY FOR COMMERCIAL VERSIONS ONLY
-02 FWD BLADEFOLD ASSY FOR CANADIAN VERSIONS ONLY
- TOLERANCE ON DECIMAL .X ± .1
- LAST SECTION LETTER USED "L"
- DRILL NO. 30 (Ø.128) HOLE THRU -37 AND AND -25 (COMPONENT OF -09 ASSY). INSERT 803073 SET PIN, AND GRIND FLUSH WITH -37.

WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS MOST EXTENDED POSITION (-HANDLE LOCKED ON LOWEST HOOK), DRILL A .25 DIA HOLE THROUGH THE OUTER TUBE .35 BELOW THE BOTTOM OF THE INNER TUBE AND INWARD FROM THE OUTER SIDE OF THE OUTER TUBE. UNLOCK THE INNER TUBE CRADLE ASSEMBLY AND MOVE IT TO ITS LOWEST, MOST RECESSED POSITION. MATCH DRILL THE INNER TUBE TO THE HOLE JUST DRILLED IN THE OUTER TUBE, .25 DIA.

INSTALL TEFLON TUBE BUSHING INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING 1/8" DIAMETER DRILL. INSERT 803073 SET PIN, AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 8 PL 1/2 PL EA BUSHING

GRIND BUSHING AND WELD TO CONTOUR OF TUBE.

ALIGN CRADLE ASSEMBLY 90 DEGREES FROM THE CENTERLINE AXIS OF THE BUSHING ON THE OTHER END OF THE TUBE. WELD GUSSET ON CENTER WITH TUBE AND BOTTOM OF CRADLE ASSEMBLY.

CHAMFER EDGE FOR BETTER WELDING.

TAP HOLE TO 1/4-20 THRU.

INSTALL CL-40-SBP-3 DETENT BALL INTO HOLDING FIXTURE SO THAT THE BALL IS POSITIONED SLIGHTLY ABOVE FLUSH WITH THE TUBE SEAT SURFACE. ALIGN THE TUBE IN THE FIXTURE AND MARK THE BALL CONTACT LOCATION ON THE TUBE. USE A SMALL PUNCH TO DIMPLE THE TUBE AT THE MARKED LOCATION. INSERT THE TUBE BACK INTO THE FIXTURE AND ADJUST FOR PROPER STOWING.

PERMISSIBLE TO SUBSTITUTE EQUIVALENT AN960 WASHER FOR NAS1149 WASHER UNTIL CURRENT STOCK IS DEPLETED.

PAINT ALL ASSEMBLIES AND WELDMENTS AS REQUIRED, EXCEPT WHERE NOTED, 23663U W OHSA YELLOW, PER FED-STD-525.

NO PAINT REQUIRED, CHEM FILM ONLY WHERE APPLICABLE. PER PREMIER SPEC 008-93003.

STITCH APPROX AS SHOWN, PER FED-STD-751.

PERMISSIBLE TO TRIM NYLON WASHERS OR SUBSTITUTE WITH THINNER MS51859 EQUIVALENT.

DISENGAGE -53 HANDLE ASSY (BOTH SIDES) PRIOR TO INSTALLATION AND REMOVAL OF -01 OR -02 BLADEFOLD ASSY TO AIRCRAFT.

W6 41237

RELEASED
06-01-20

ECO
5007
5161
6262

SEE SEPARATE PARTS LIST B67-43001PL

MATERIAL:		SUBSTITUTION SPECIFIED:		DATE: 10/12/95		PREMIER AVIATION, INC.	
FINISH:		TOLERANCES UNLESS SPECIFIED:		CHECKED BY: RICK REYNOLDS		3000 Aviation Parkway, Grand Prairie, Texas 75002	
		DECIMALS ANGLES		DATE: 08/12/95		TITLE: BLADE FOLD KIT	
		.10 .03 .125 .010		APPROVED BY: WALT HAMAKER		DATE: 08/12/95	
		WGT: RIVET ASSEMBLY		RELEASED BY:		SCALE: 1:1	
		EST: 01/22/96		RECEIVED DRAWN BY: PRO/ENGINEER		REV. 01	
		08/14/96		SHEET 1 OF 45		REV. 01	

ORIGINAL

